

# Work Order ID 55140



Page 1

January 7, 2010 8:35:50 AM

Item ID: D044-719-011

Accept

Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 07/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: *PL*Date: *10-1-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3281	Rev D

100 *for ME 10/01/28*

DOCUMENT CONTROL

DC

Document Control

Memo 0.00

Photocopy bluefile and create labels per PPP D044-719-011 CHG003

*S 10/01/28*110 *10-1-21*

Pick Kit

0.00

Packaging

Memo 0.00

Packaging

*Pot f*120 *27 S 10/01/28*

QC4- 100% Inspect kits for completeness

0.00

QC

Memo 6.00

Quality Control

*(x10) f*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55140**

Page 2

January 7, 2010 8:35:50 AM

Item ID: D044-719-011

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



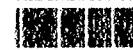
Start Date: 07/01/2010 Start Qty: 100.00



Cust Item ID:



Required Date: 15/01/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



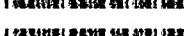
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

0.00

*PC 10/01/28 (10)*

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D044-719-011

Location:

PPP Rev: C

140



QC21- Final Inspection - Work Order Release

0.00

*10/01/29 (J)*

QC

Quality Control

Memo

0.00

*MF*

*10-1-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

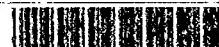
NOTE: Date & initial all entries

**Picklist Print**

Page 1

January 7, 2010 8:35:57 AM

Work Order ID: 55140



Parent Item: D044-719-011



Parent Item Name: Cabin Floor Protector

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments: IPP Rev:A 04.09.17 New Issue KJ/JLM

Start Qty: 10.00

IPP Rev: B 04.02.02 Material change to Lexan 0.125" DL

IPP Rev C. 07.08.07 Thermoformed in house DL

IPP Rev D. 08.04.14 Material change to Lexan 0.093" DL

Required Qty: 10.00

D2854-1-100



Manufactured

No

110

Each

35.0000

80.0000



10-1-27 B55444 S

S+10



Velcro Strip, Looped

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

ST

35

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40490

4

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47415

31

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D2854-3-100



Manufactured

No

110

Each

43.0000

80.0000



B55445 10-1-27 S

S+10



Velcro Strip, Hooked

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

43

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37862

4

---

39589

4

---

40491

4

---

47416

31

---

D3281-1



Manufactured

No

110

Each

1.0000

10.0000



10-1-27 S 10x

S+10



Floor Protector, Fwd LH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

ST

1

---

47339

1

---

1 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Picklist Print**

Page 2

January 7, 2010 8:35:57 AM

Work Order ID: 55140



Parent Item: D044-719-011



Parent Item Name: Cabin Floor Protector

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments: IPP Rev:A 04.09.17 □ New Issue □ KJ/SLM

Start Qty: 10.00

IPP Rev: B 04.02.02 Material change to Lexan 0.055" DL

Required Qty: 10.00

IPP Rev C. 07.08.07 Thermoformed in house DL

IPP Rev D. 08.04.14 Material change to Lexan 0.055" DL

D3281-2



Manufactured No

110

Each

2.0000

10.0000



10-1-27 SV

Floor Protector, Fwd RH

+10

WarehouseLocationLoc QtyLoc Code

Main Warehouse

ST

2

40473

1

47340

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D3281-3



Manufactured No

110

Each

0.0000

10.0000

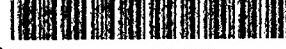


Floor Protector, Aft LH

+10

B55143 10-1-27 SF

D3281-4



Manufactured No

110

Each

2.0000

10.0000



Floor Protector, Aft RH

+10

8X

B55144 10-1-27 SF

WarehouseLocationLoc QtyLoc Code

Main Warehouse

ST

2

40475

1

47342

1

I

I

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

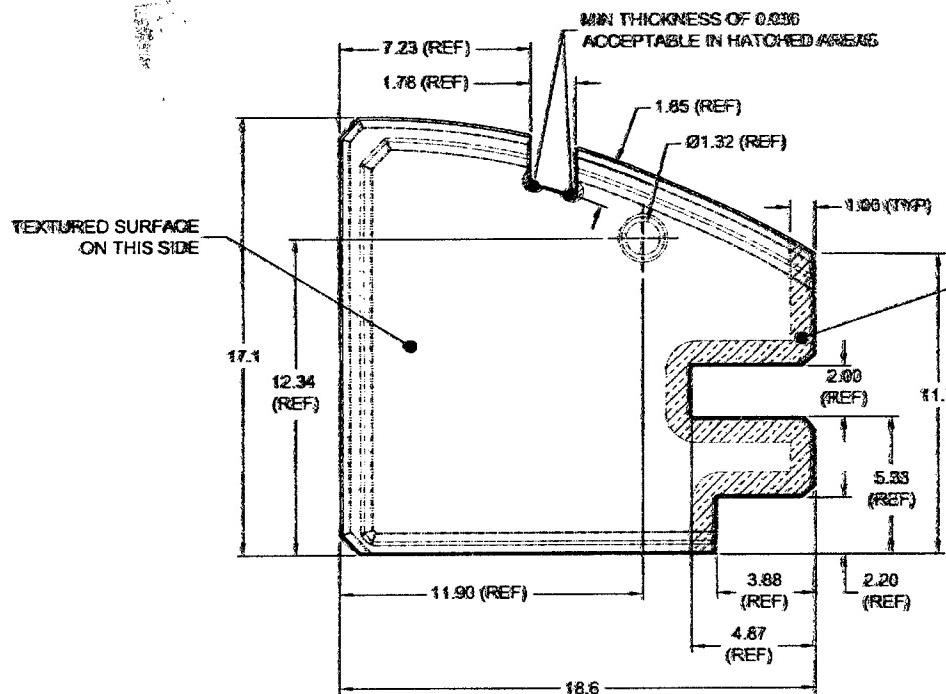
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3281-1 FLOOR PROTECTOR

21-1 NOTES:

HERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEKS 093-F6006-02)

FINISH: NONE

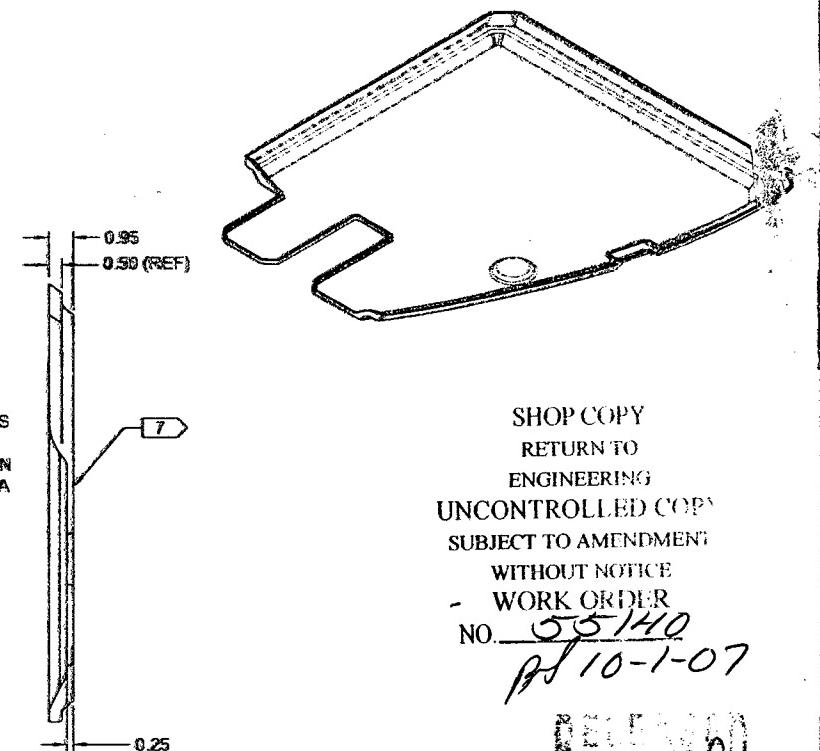
CLEARANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

INITS: INCHES UNLESS OTHERWISE NOTED

REAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.55 lb



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
- WORK ORDER  
NO. 55140  
PJ 10-1-07

*RECEIVED  
05-04-11 WD*

B	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.060, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-4 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS: COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.08
B	NOW LEXAN, DIMS AS MANUFACTURED	OP	05.11.25
A	NEW ISSUE	OP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>P</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PS</i>	REV. D	
MFG. APPR.	<i>PS</i>	DRAWING NO.	SHEET 1 OF 4
APPROVED	<i>PS</i>	D3281	
GE APPR.	<i>PS</i>	TITLE	SCALE
DATE	08.03.28	FLOOR PROTECTOR	MTS

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W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

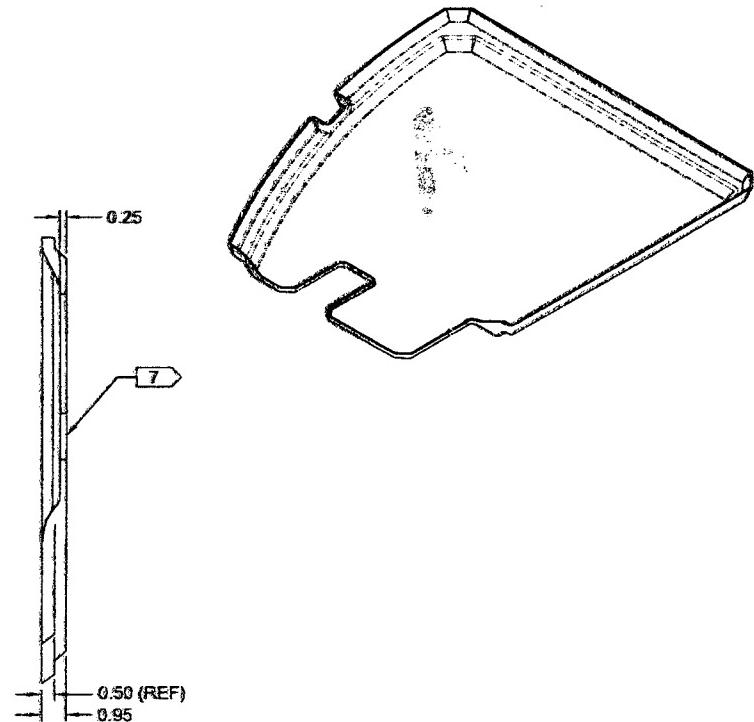
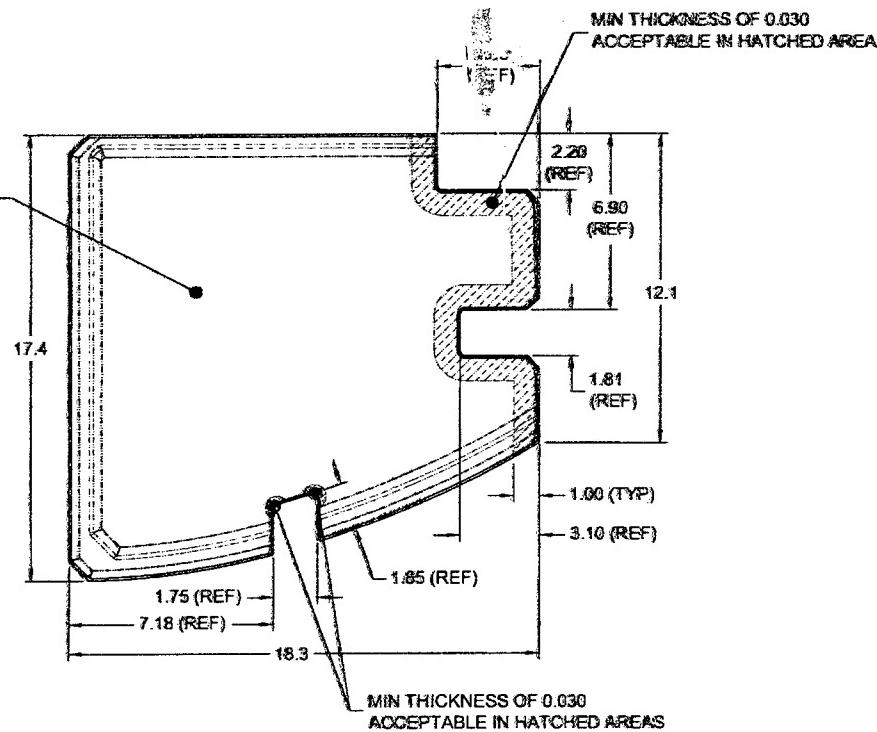
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 . 7 . 6 . 5 . 4 . 3 . 2 . 1 .

TEXTURED SURFACE  
ON THIS SIDE



### D3281-2 FLOOR PROTECTOR

#### 21-2 NOTES:

HERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC IMLEXS.093-F6006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "XXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.97 lb



W/0 55-140

DESIGN	IP	DART AEROSPACE LTD	
DRAWN	IP	MANTICOURT, ONTARIO, CANADA	
CHECKED	IP	REV. D	
MFG. APPR.	IP	DRAWING NO. D3281 SHEET 2 OF 4	
APPROVED	IP	TITLE FLOOR PROTECTOR	
DE APPR.	IP	SCALE NTS	
DATE 08.03.28		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRETS AND IS THE PROPERTY OF DART AEROSPACE LTD. NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OUTSIDE DART AEROSPACE LTD BY ANY PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

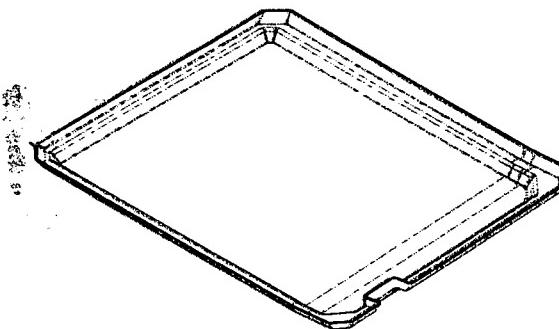
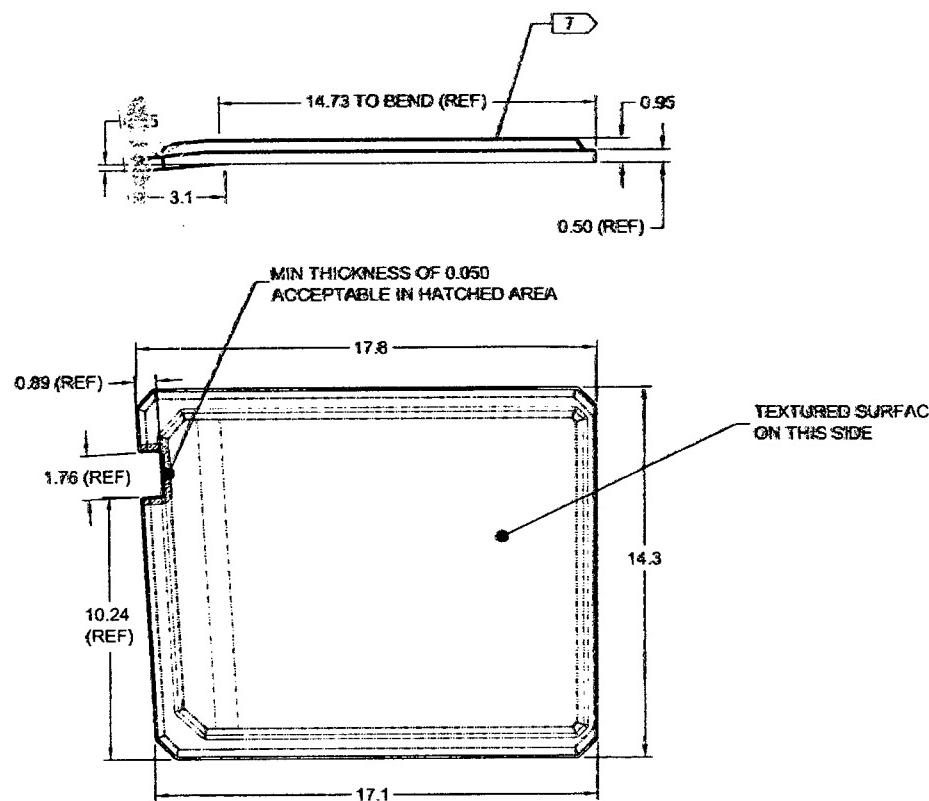
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



### D3281-3 FLOOR PROTECTOR

#### 321-3 NOTES:

HERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

MATERIAL: LEXAN FG006, BLACK No. 701, 0.055" THICK  
(REF DART SPEC MLEXS 093-FG006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb



w/1

55140

*08.03.28*

DESIGN	40	DART AEROSPACE LTD
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA
CHECKED	IS	DRAWING NO. REV. D
MFG. APPR.	W/10	D3281 SHEET 3 OF 4
APPROVED	AM	TITLE SCALE
DE APPR.		FLOOR PROTECTOR NTS
DATE	08.03.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION AND IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

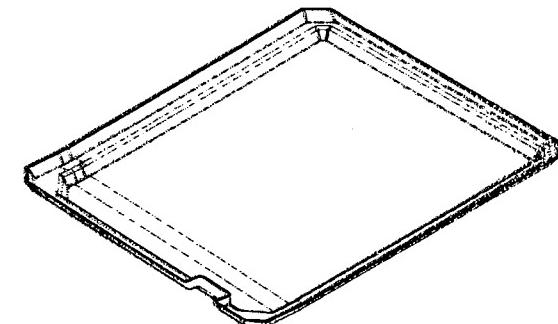
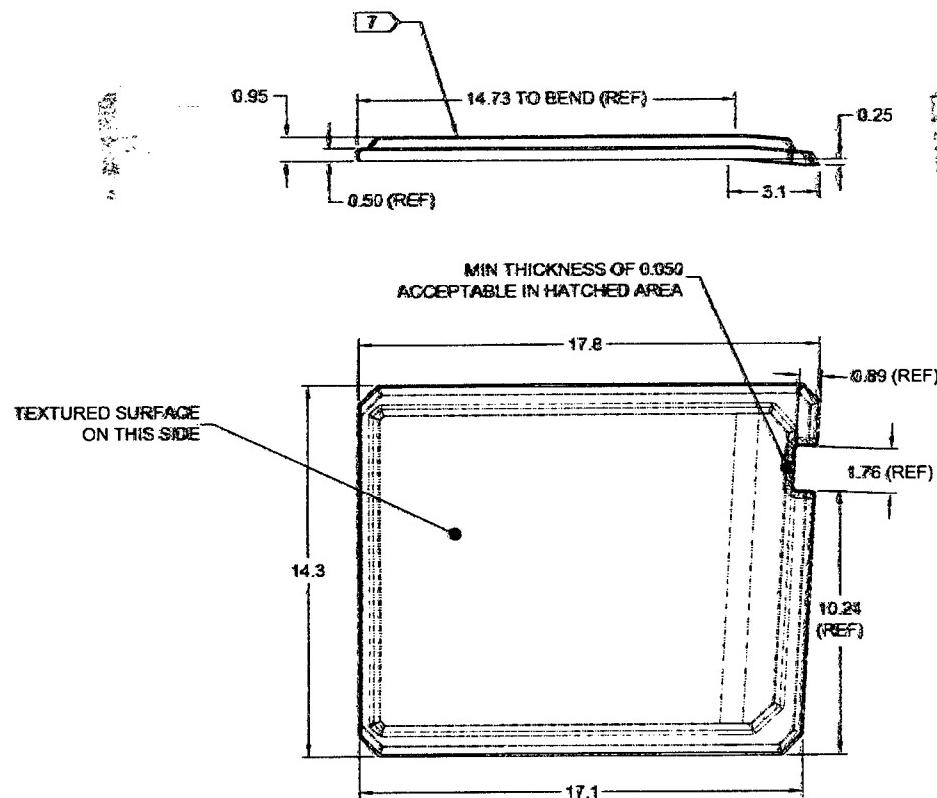
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



### D3281-4 FLOOR PROTECTOR

#### 81-4 NOTES:

HERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

MATERIAL: LEKAN FS006, BLACK NO. 701, 0.053" THICK  
(REF DART SPEC MLEKS.093-P8006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "XXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.87 lb



DESIGN	49	DART AEROSPACE LTD	
DRAWN	PF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PF	REV. D	
MFG. APPR.	DP	DRAWING NO.	
APPROVED	AM	D3281	SHEET 4 OF 4
DE APPR.	AM	TITLE	
DATE	08.03.28	SCALE	
		FLOOR PROTECTOR	
INTS			

*w/0 55140*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

## 2.0 GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

## 3.0 INSTALLATION PROCEDURE

The Dart D044-719-011 Cabin Floor Protectors should be installed as follows:

- 3.1 Remove any existing floor protection that may interfere with the installation of the D3281-1, D3281-2, D3281-3, or D3281-4 Floor Protectors.
- 3.2 Apply qty(2) 10" long velcro strips to the bottom of all four Floor Protectors as shown in Figure 1. Remove adhesive back.
- 3.3 Place the D3281-1, D3281-2, D3281-3, and D3281-4 Floor Protectors on the cabin floor of the aircraft as shown in Figure 1. Push the trays down so they are firmly seated on the floor (ie. will not move during flight) and will not interfere with any of the aircraft controls.

NOTE: Previous interior modifications may necessitate minor trimming of D3281-1/-2/-3/-4 to facilitate installation. Trim to fit as required.

NOTE: To clean floor protectors, use mild soap or detergent with warm or cold water. Do not use abrasive or highly alkaline cleaners.

## 4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the Cabin Floor Protectors. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-719-011 Cabin Floor Protectors	3.9 lb 1.8 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	195 in-lb 2.3 m-kg

## 5.0 PARTS LIST

Qty	Part Number	Description
-011	X D044-719-011	CABIN FLOOR PROTECTORS
1	D3281-1	FLOOR PROTECTOR, FWD LH
1	D3281-2	FLOOR PROTECTOR, FWD RH
1	D3281-3	FLOOR PROTECTOR, AFT LH
1	D3281-4	FLOOR PROTECTOR, AFT RH
8	D2854-1-100	LOOPED VELCRO STRIP
8	D2854-3-100	HOOKED VELCRO STRIP

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Revision: A  
Date: 04.06.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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